



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

\$212512

RBST4241-5
Job Sheet 199257



Part No: RBST4241-5

Job Qty: 24 pcs

Part Name: Roller



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/15/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/7/19

Description:

Type: SOLD

Note: RBST4241 REV.1 IPP REV:A 18.01.17 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

DAS Job Routing

4 9-89 Due					Standard	Workcenter/Supplier		Sign-off
Op No	Operation	Qty	Start Date	Date	Setup Run Hrs Hrs	Workcenter / Supplier Lead Time		
100	Outsource - 16 - Grinding	24 pcs	10/7/19			AFF001-VC	8	2019-08-22
110	Packaging 2-1 - Receive - B4B	24 pcs	10/7/19		0.00 0.00	Packaging 2 - 1 - B4B		
						Packaging 2 - 2 - B4B		
						Packaging 2 - 3 - B4B		
						Packaging 2 - 5 - B4B		
						Packaging 2 - 4 - B4B		
						Packaging 2 - 6 - B4B		
						Packaging 2 - 7 - B4B		
						Packaging 2 - 8 - B4B		
						Packaging 2 - 9 - B4B		
						Packaging 2 - 10 - B4B		
						Packaging 2 - 11 - B4B		
						Packaging 2 - 12 - B4B		
						Packaging 2 - 13 - B4B		DP SEP 11 2019
						Packaging 2 - 14 - B4B		
						Packaging 2 - 15 - B4B		
						Packaging 2 - 16 - B4B		
						Packaging 2 - 17 - B4B		
						Packaging 2 - 18 - B4B		
						Packaging 2 - 19 - B4B		
						Packaging 2 - 20 - B4B		
						Packaging 2 - 21 - B4B		
						Packaging 2 - 22 - B4B		
						Packaging 2 - 23 - B4B		
						Packaging 2 - 24 - B4B		
						Packaging 2 - 25 - B4B		
						Packaging 2 - 26 - B4B		
						Packaging 2 - 27 - B4B		
						Packaging 2 - 28 - B4B		
						Packaging 2 - 29 - B4B		
						Packaging 2 - 30 - B4B		



Container No: S212512

Part: RBST4241-5
Job No: 199257
Serial No/Batch: S212512
Revision: 1
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/11/19



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Job No: 199257

Serial No/Batch: S212512

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 08/11/19

120 QC 6	24 pcs	10/7/19	0.00 0.00	Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				QC 6 - 9	
130 Packaging 3-1 - Stock - B4B	24 pcs	10/7/19	0.00 0.00	QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
				Packaging 3 - 1 - B4B	
140 QC 21 - SA	24 pcs	10/7/19	0.00 0.00	Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	24 pcs	10/7/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 100 - ISSUE P/O: 44319

TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF

Descriptions: 89031009 ***NOTE*** One dowel pin makes 6 pcs.

110 - (Receive & Inspect for Damage & Mat'l Certs)

120 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location: _____)

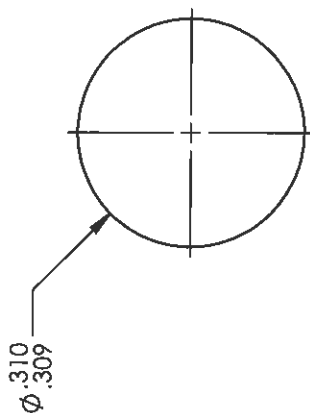
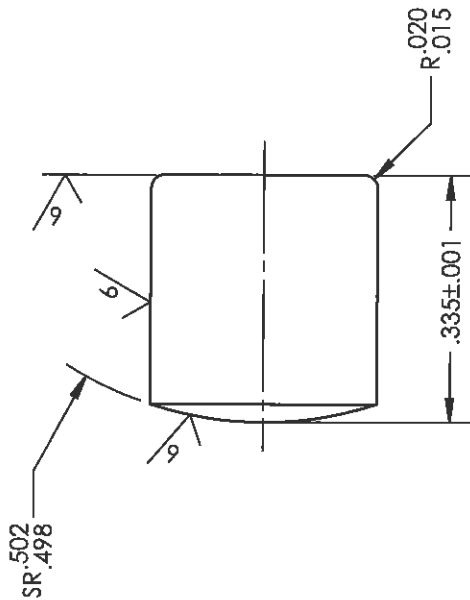
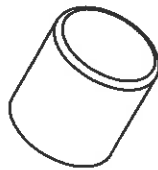
140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
89031009	Plug and Pin Gauge	3.9840 Ea (.166 ea)	100-Outsource - 16 - Grinding	5049637
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Outsource - 16 - Grinding	89031009	4	25	0
Part Specifications				
Specifications could not be found.				

Plex 8/21/19 3:49 PM Dart.Guerin.Kimberley

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REV		ECR		REVISIONS		DESCRIPTION		DATE	INITIAL	APPROVED



TITLE
DRILL PRESS SWAGING TOOL

DWG NO. RBST4241-5 REV 1

MATERIAL: STEEL		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT: RC 55-60		DIMENSIONS ARE IN INCHES	
FINISH: XX		FRACTIONS 1/8	
SPEC: 1. BREAK ALL SHARP EDGES		ANGLES 2.5°	
DRAWN BY: DD 04/05/2017		SURFACES = 125	
CHECKED: SM 04/05/2017		1. THIS TOOL IS FOR DRILL PRESS SWAGING	
OPPS APPR: AA 04/05/2017		2. DIMENSIONS AND TOL PER ASME Y14.5M-2009	
QA APPR: JL 04/05/2017		3. INTERPRET DIM AND TOL PER USED ON MODEL	
APPROVED: JAG 04/06/2017		SCALE: 4:1	
		DATE: 4/5/2017	
		SHEET 4 OF 9	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 199257 M-5
19-08-15

(5)

ROLLER

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube Machining Large Fab ☐ Cross tube Small Fab Finishing ☐ Eng. (Non-AW) Prod. Eng, Coord. Rec/Store/Packaging ☐ Engineering Water Jet Supplier Quality ☐			
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS042) _____			
Description Work Order Deviation		Disposition					
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY					
		Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	
		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
Completed By _____		Lead hand / Supervisor _____					
QC / QA Coordinator _____							



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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044319



Supplier: AFF001-VC
Affutage K.G. Inc.
11455 Philippe Panneton Ave.
Montreal
QC
H1E 4M1 Canada
Phone: 514 323 0192 514 323 6631
Fax: 514 323 6631

PO No: POHB044319
PO Date: 8/22/19
Due Date: 9/3/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pyrm Terms: Net 30

Freight Terms:
Special Comments:

E-MAILED
2019-08-27

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	199257	RBST4241-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 ***NOTE*** One dowel pin makes 6 pcs.	Firmed -		9/3/19	24 pcs	0 pcs	24 pcs	\$16.00/pcs	\$384.00
				X24		SEP 11 2019	5212512				DP
2	199224	RBST2812-P-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 ***NOTE*** One dowel pin makes 6 pcs.	Firmed -		9/3/19	12 pcs	0 pcs	12 pcs	\$16.00/pcs	\$192.00
				X12		SEP 10 2019	5212510				DP
3	196252	RBSC7028-P-5	Cutter 1-Issue P/O to KG Grinding; P/O _____ 2-Grind as per DWG. RBSC7###-P-5 Rev6 3- Certificate of Conformity is required	Firmed -		9/3/19	10 pcs	0 pcs	10 pcs	\$60.00/pcs	\$600.00
				X10		SEP 10 2019	5203376				DP
Grand Total: \$1,176.00											

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Canada

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PURCHASE ORDER

POHB044319



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/27/19 9:04 AM Dart.Guerin.Kimberley

AFFUTAGE KG INC. KG GRINDING INC.

11455 avenue Philippe Panneton
Montréal, Québec H1E 4M1
Tel: (514) 323-0192
Fax: (514) 323-6631

Packing Slip

Packing Slip No.: 11228
Date: 04-09-2019
Page: 1

Sold to:		Ship to:	
DART AEROSPACE LTD CHANTAL LAVOIE 1270 Aberdeen Street Hawkesbury, On K6A 1K7		DART AEROSPACE LTD CHANTAL LAVOIE 1270 Aberdeen Street Hawkesbury, On K6A 1K7	
Order No.: HB044319		Sold By:	
Shipped By:		Tracking No.:	

Item No.	Unit	Description	Ordered	Quantity Shipped	B/O
D.Modification	Each	DOWEL PIN MODIFIED TO RBST4241-5	24	24	DAS 81 9-89
D.Modification	Each	DOWEL PIN MODIFIED TO RBST2812-P-5	12	12	
D.Modification	Each	TOOL MODIFIED TO RBSC7028-P-5	10	10	
RECEIVED SEP 06 2019 DART AEROSPACE LTD.					